

5/17/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle


DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-043**Job Sheet 177743****Part No:** D119-646-043**Job Qty:** 1 ea**Part Name:** AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 5/17/18**Job Tracking No:****Due Date:** 6/25/18**Created By:** Michelle Gagnon-Donovan**Type:** SOLD**Description:**

Note: DWG IIN-D119-646 REV D, D3905-041 REV E SHEETS 1,2,5,6, 8-14 IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

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Container No: S083281**Part:** D119-646-043**Job No:** 177743**Serial No/Batch:** S083281**Revision:****Inspector:****Exp Date:****Instructions:**

Date: 06/22/18

Dart Aerospace Ltd.
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CANADA
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FILED 5/17/18 11:54 AM Dart. Gagnon. Michelle

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/25/18	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		6/25/18	0.00	3.68	Skid tubes-1		
120	HandFinish	1 pcs		6/25/18	0.00	1.56	HandFinish1		
130	QC	1 pcs		6/25/18	0.00	0.00	QC7-1		
140	QC	1 pcs		6/25/18	0.00	0.00	QC5		
170	Skid tubes	1 pcs		6/25/18	0.00	3.68	Skid tubes-1		
180	QC	1 pcs		6/25/18	0.00	0.00	QC5		
190	Skid tubes	1 pcs		6/25/18	0.00	3.68	Skid tubes-1		
200	QC	1 pcs		6/25/18	0.00	0.00	QC5		
210	QC	1 pcs		6/25/18	0.00	0.00	QC10		
220	HandFinish	1 pcs		6/25/18	0.00	1.56	HandFinish2		
230	SprayPaint	1 pcs		6/25/18	0.00	0.42	Spray Paint		
235	Outsource	1 pcs		6/25/18			ATE003-VC		
240	QC	1 pcs		6/25/18	0.00	0.00	QC14		
250	HandFinish	1 pcs		6/25/18	0.00	1.56	HandFinish4		
260	QC	1 pcs		6/25/18	0.00	0.00	QC5		
270	HandFinish	1 pcs		6/25/18	0.00	1.56	HandFinish4		
280	QC	1 pcs		6/25/18	0.00	0.00	QC5		
285	HandFinish	1 pcs		6/25/18	0.00	1.56	HandFinish3		
286	QC	1 pcs		6/25/18	0.00	0.00	QC5		
289	DC	1 pcs		6/25/18	0.00	0.00	DC		
295	Packaging	1 pcs		6/25/18	0.00	0.00	Packaging3-1		
300	QC21-FG	1 Ea		6/25/18	0.00	0.00	QC21		

Part Op 110 - Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) Cut FWD Descriptions: end of tube as per dwg D3905 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5- Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9480 8- Drill FWD cap holes using DT8215.

170 - Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.) A/R Sikaflex-291 432013 Sikaflex expire date: 19-03-06 Start: 18-06-27 Time: 18-06-27 Finish: 18-06-27 Time: 18-06-27 ***** (Adhere for 12 hours) *****

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & D

190 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 138839

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Deburr & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

200 - TEST FIT USING FIXTURE DT10091.

220 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

230 - *****AS PER DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 138862 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138875

250 - 1-Install inserts as per Dwg D3905.

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 M138782 Sikaflex expire date: 18/11/2 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M138841 3-Inspect for foreign objects as per QSI 024 4-Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 18/11/2

Sikaflex expire date: 18/11/2 5-Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 18/11/2 Sikaflex expire date: 18/11/2 6- Install (2)D5101-041 and (1)D5101-047 as per dwg by using DT10117

289 - Photocopy bluefile & type labels per PPP D119-646-043 CHG 005

Job BOM

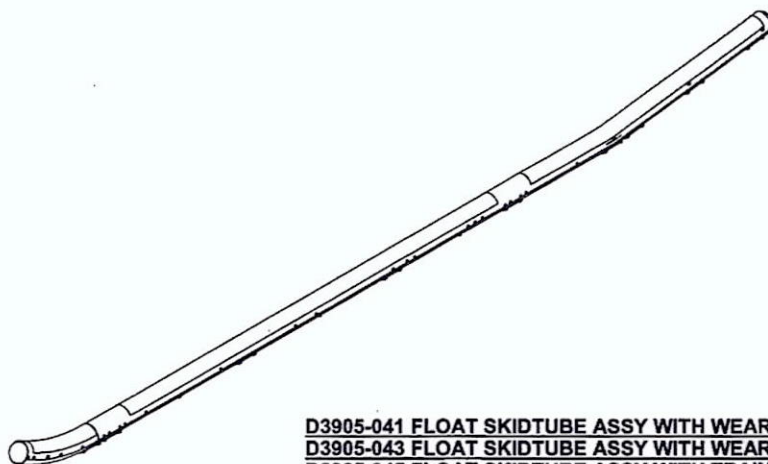
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 Ea (1 ea)	90-Start up Operation	5081201
D3885-3	Float Web	1 Ea (1 ea)	170-Skidtubes	5000623
D2579	Crossbolt Spacer	2 Ea (2 ea)	190-Skidtubes	5051552
D2855-5	Cap	1 Ea (1 ea)	190-Skidtubes	5066894
D3681-1	Spacer	8 Ea (8 ea)	190-Skidtubes	5022530 x 5 5084741 x 3
D3903-1	Spacer	12 Ea (12 ea)	190-Skidtubes	5084655
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-HandFinish	5007279
D3683-3	Insert	12 Ea (12 ea)	250-HandFinish	NIA
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-HandFinish	5058138
AN3C4A	Bolt	6 Ea (6 ea)	270-HandFinish	506842
AN3C5A	Bolt	38 Ea (38 ea)	270-HandFinish	5057153
AN4C46A	Bolt	3 Ea (3 ea)	270-HandFinish	5006303
D2855-3	Cap	1 Ea (1 ea)	270-HandFinish	5066002
D3492-5	Plug	16 Ea (16 ea)	270-HandFinish	5060337
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270-HandFinish	F150074
D3672-3	Washer, Phenolic	12 Ea (12 ea)	270-HandFinish	NIA
D3847-1	Wearpad	8 Ea (8 ea)	270-HandFinish	5054297
D3847-11	Wearpad	1 Ea (1 ea)	270-HandFinish	5026852
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270-HandFinish	F159649
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270-HandFinish	5072225
D5101-3	Insert	6 Ea (6 ea)	270-HandFinish	F158939
D5101-5	Insert	6 Ea (6 ea)	270-HandFinish	F158796
MS21043-4	Nut	3 Ea (3 ea)	270-HandFinish	5062296
MS24694-C52	Screw	2 Ea (2 ea)	270-HandFinish	F1137951
MS27039C4-08	Screw	12 Ea (12 ea)	270-HandFinish	NIA
NAS1149C0332R	Washer	44 Ea (44 ea)	270-HandFinish	5056493
NAS1149C0463R	Washer	12 Ea (12 ea)	270-HandFinish	NIA
NAS1611-005	O-Ring 5034466 (x10)	16 Ea (16 ea)	270-HandFinish	5057657 (x6)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	45	0
170-Skidtubes	D3885-3	1	4	0
190-Skidtubes	D2579	2	133	0
	D2855-5	1	85	0
	D3681-1	8	93	0
	D3903-1	12	43	0
250-HandFinish	ALS4-1032-130	42	14,156	0
	D3683-3	12	219	0
270-HandFinish	ALS4-1032-225	1	5,405	0
	AN3C4A	6	2,369	0
	AN3C5A	38	1,802	0
	AN4C46A	3	102	0
	D2855-3	1	30	0
	D3492-5	16	234	0
	D3672-1	2	1,059	0
	D3672-3	12	1,164	0
	D3847-1	8	58	0
	D3847-11	1	26	0
	D5101-041	2	14	0
	D5101-047	1	5	0
	D5101-3	6	56	0
	D5101-5	6	42	0
	MS21043-4	3	965	0
	MS24694-C52	2	184	0
	MS27039C4-08	12	226	0
	NAS1149C0332R	44	7,418	0
	NAS1149C0463R	12	260	0
	NAS1611-005	16	663	0

Part Specifications
Specifications could not be found.

Plex 5/17/18 11:54 AM Dart.Gagnon.Michelle



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

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 WITHOUT NOTICE
 WORK ORDER
 NO. **1777.43**

MAY 17 2018

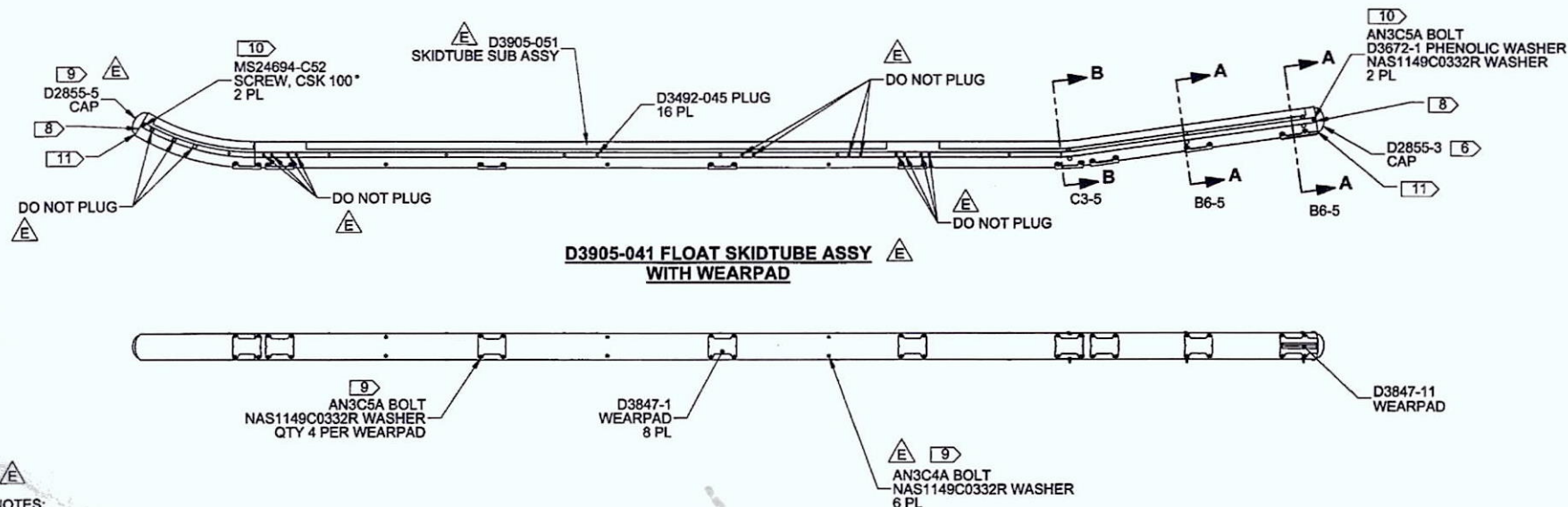
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.485 WAS Ø0.437 FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PAR15-421 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PAR17-583 ADDED DRILL JIG REF NUMBER, NCR15-5366 INCREASE RIDGE RELIEF FROM 0.060 TO 0.130. REF PAR17-574	AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-6 REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B8-, ZN A8-1) REVISED -041-043-045 DRAWING VIEWS, REVISED SECTION VIEW F-F (ZN B4-7), REVISED BOM REF. PAR13-299 AND PAR13-272	AK	14.08.08
C	(SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 46, ADD ITEM 49, MS24694-02 WAS AN3CSA, D3672-1 AND NAS1149C0332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C6-7, D8-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A5-3, A5-6, C5-7, C5-7, A5-7); ADD D18932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C6-3, C1-3, C6-4, C1-4); AN3CSA WAS AN3CA4 (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A5-7 & D7-6), REVISED NOTE IV (ZN A5-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D3905 REV. E SHEET 1 OF 14 SCALE A119 FLOAT SKIDTUBE ASSY NTS COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
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CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS	DATE 17.03.13	

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 2017-05-08
 EN 17-519

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	6	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C46A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 35.4 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

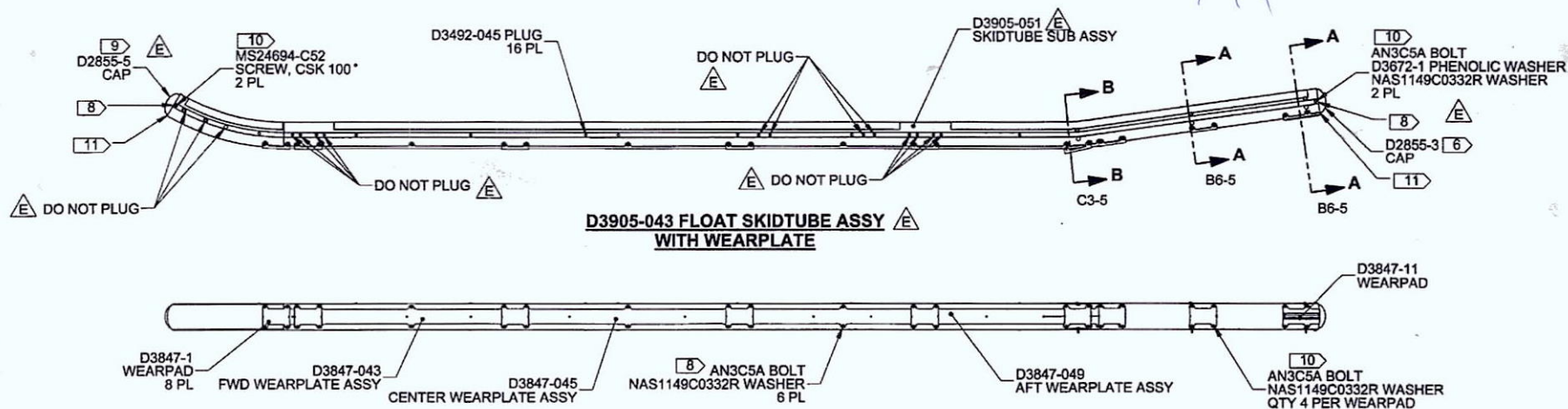
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2017-05-08

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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3905-043	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-049	AFT WEARPLATE ASSY
8	8	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3905-051	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSSBOLT SPACER ASSY
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -043	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	44	AN3C5A	BOLT
17	3	AN4C46A	BOLT
18	3	MS21043-4	NUT, SELF-LOCKING
19	2	MS24694-C52	SCREW, CSK 100*
20	44	NAS1149C0332R	WASHER
21	6	NAS1149C0416R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 42.8 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO $\varnothing 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

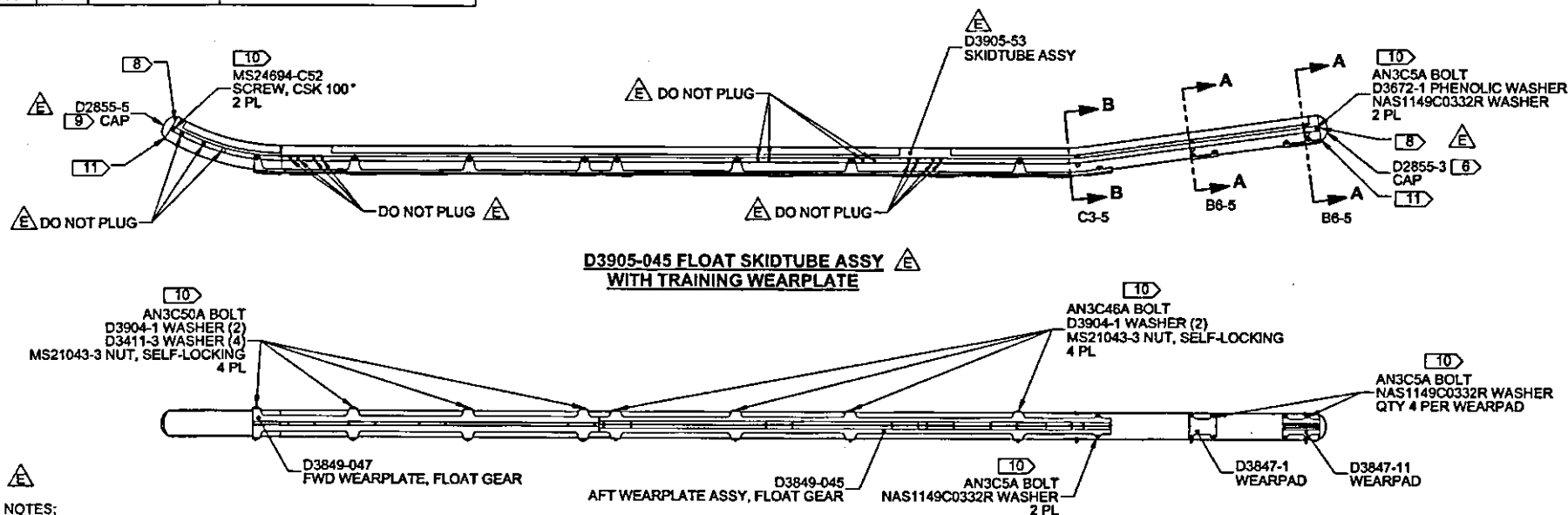
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DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 3 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	16	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	8	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 48.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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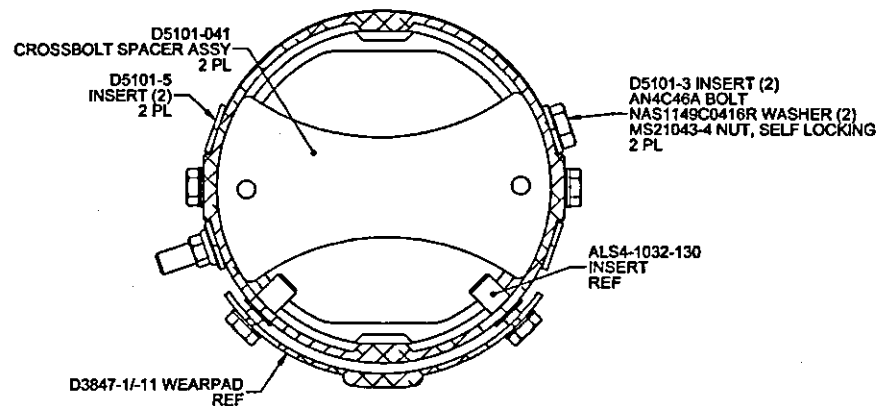
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DESIGN	AJS
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DE APPR.	DS
DATE	17.03.13

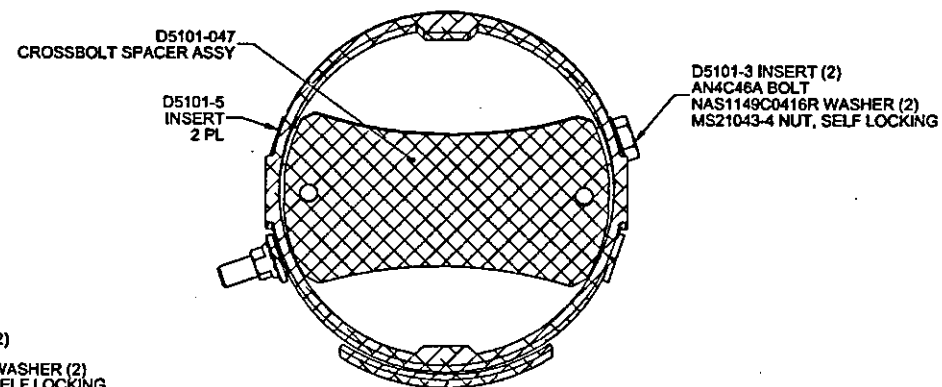
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. REV. E
D3905 SHEET 4 OF 14
TITLE SCALE
A119 FLOAT SKIDTUBE ASSY NTS

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SECTION A-A
SCALE: 12X



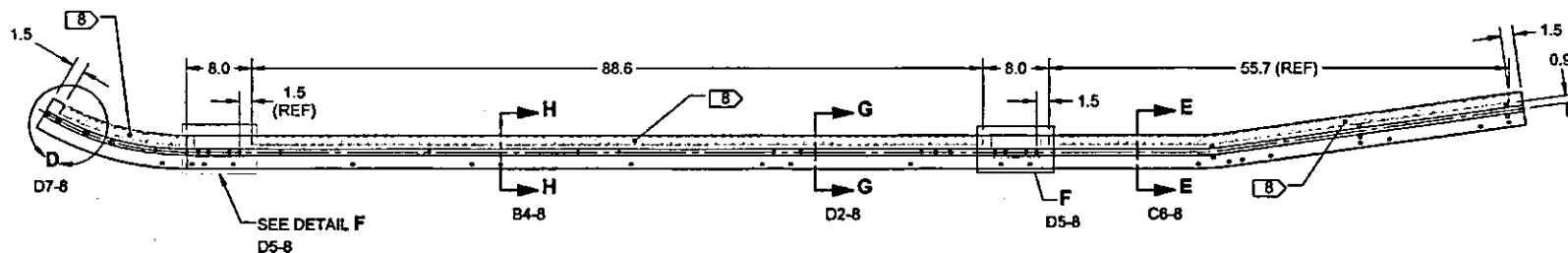
SECTION B-B
SCALE: 12X

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ITEM	QTY -051	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

NOTES:

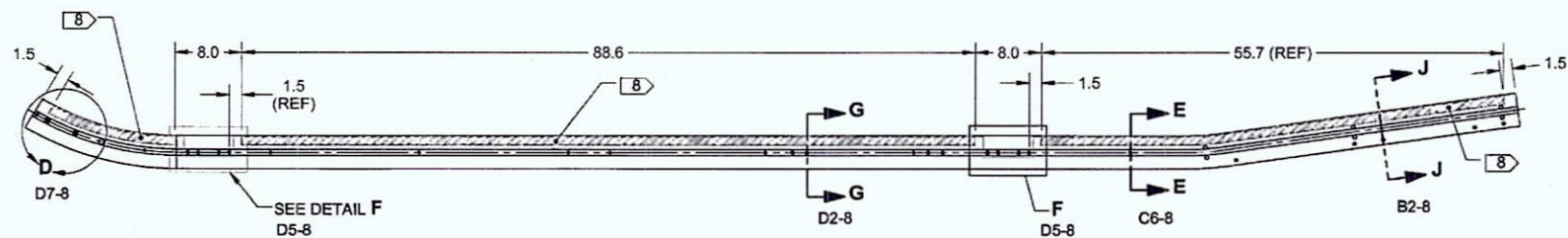
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

NOTES:

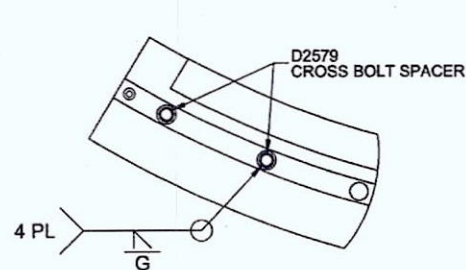
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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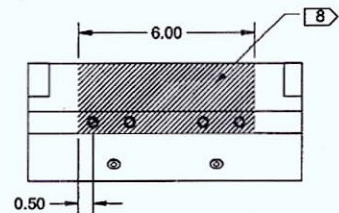
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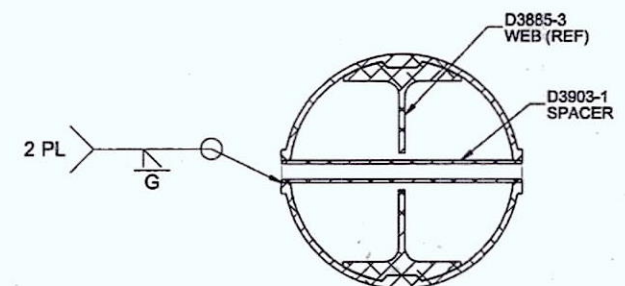
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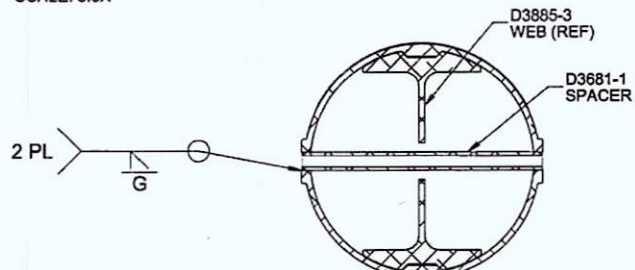
DETAIL D
SCALE: 3.5X



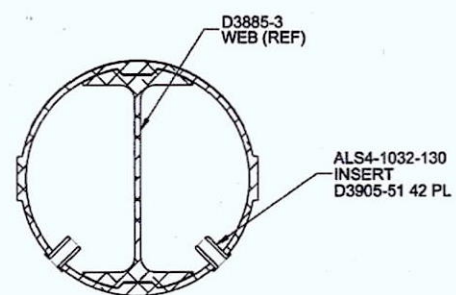
DETAIL F
SCALE: 3.5X



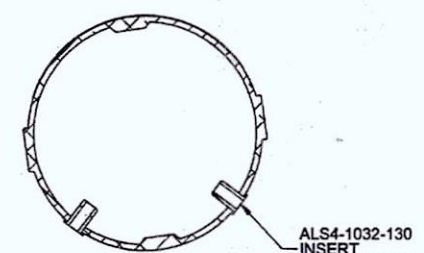
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

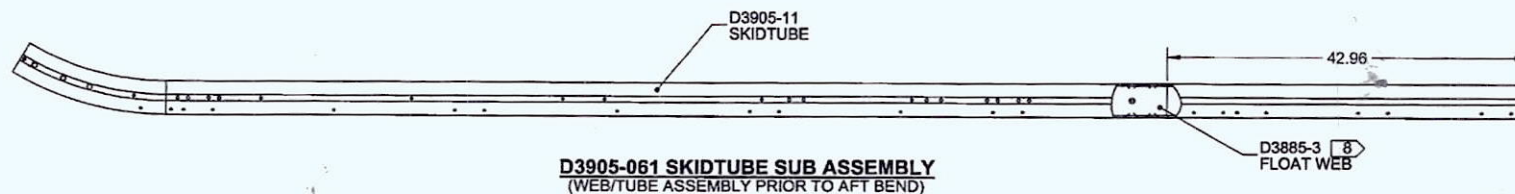
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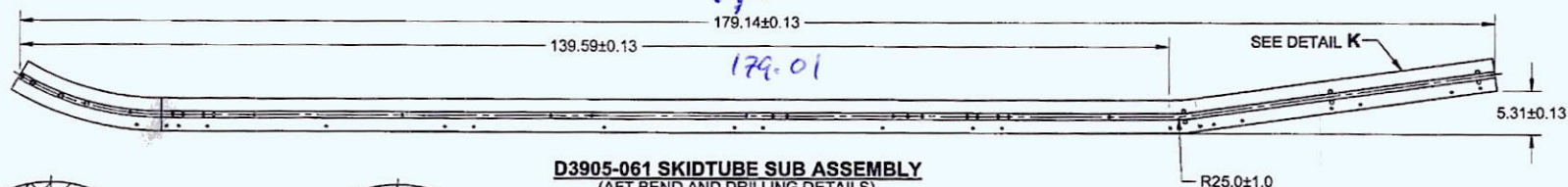
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MFG. APPR.	DD	D3905	SHEET 8 OF 14
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8 7 6 5 4 3 2 1

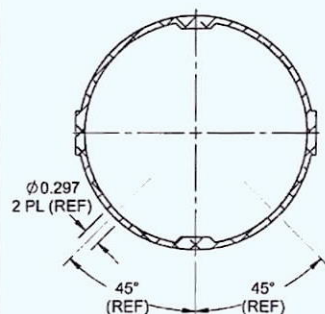
ITEM	QTY -061	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



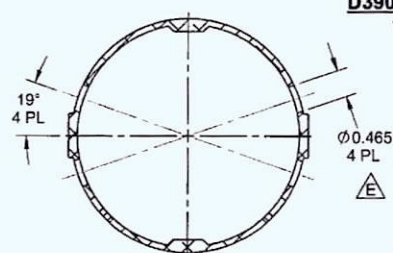
D3905-061 SKIDTUBE SUB ASSEMBLY
(WEB/TUBE ASSEMBLY PRIOR TO AFT BEND)



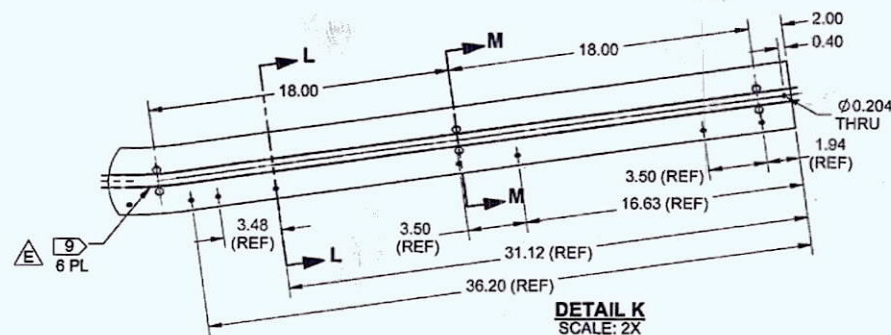
D3905-061 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION L-L
7 PL
SCALE: 7X



SECTION M-M
3 PL
SCALE: 7X



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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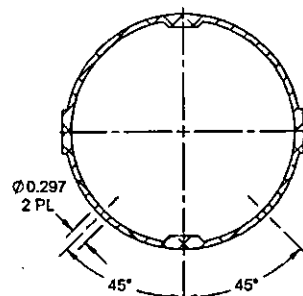
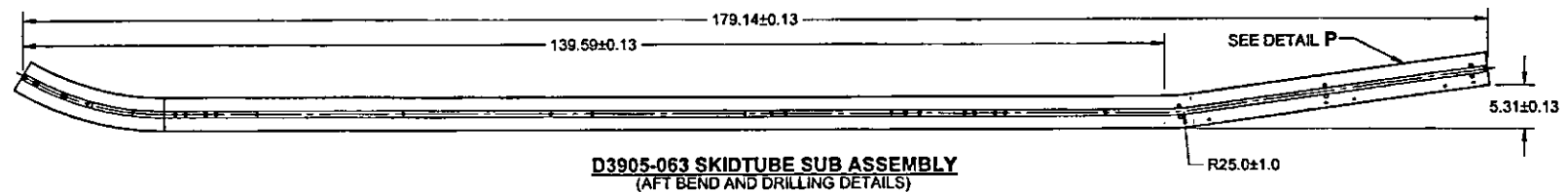
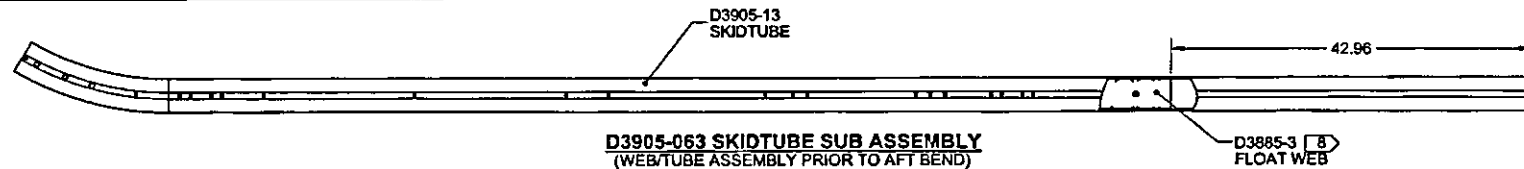
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MFG. APPR.	DD
APPROVED	HS
DE APPR.	D9
DATE	17.03.13

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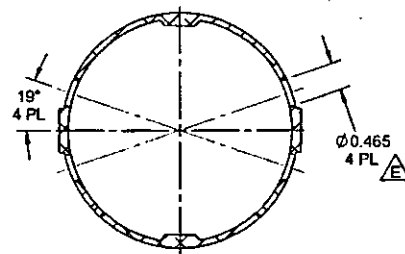
DRAWING NO. **D3905**
REV. E
SHEET 9 OF 14
SCALE
TITLE **A119 FLOAT SKIDTUBE ASSY**
NTS

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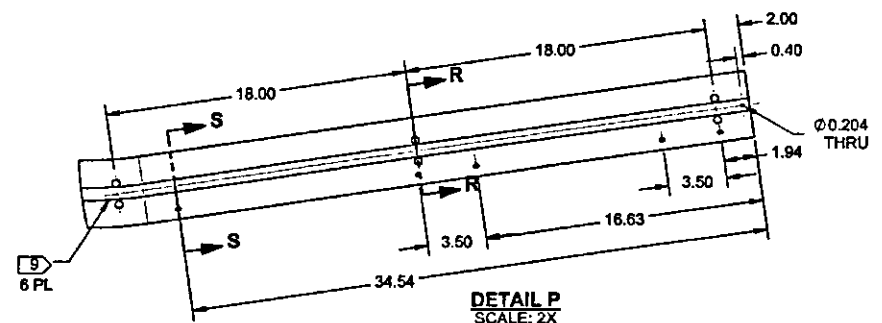
ITEM	QTY	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



SECTION S-S
5 PL
SCALE: 7X



SECTION R-R
3 PL
SCALE: 7X



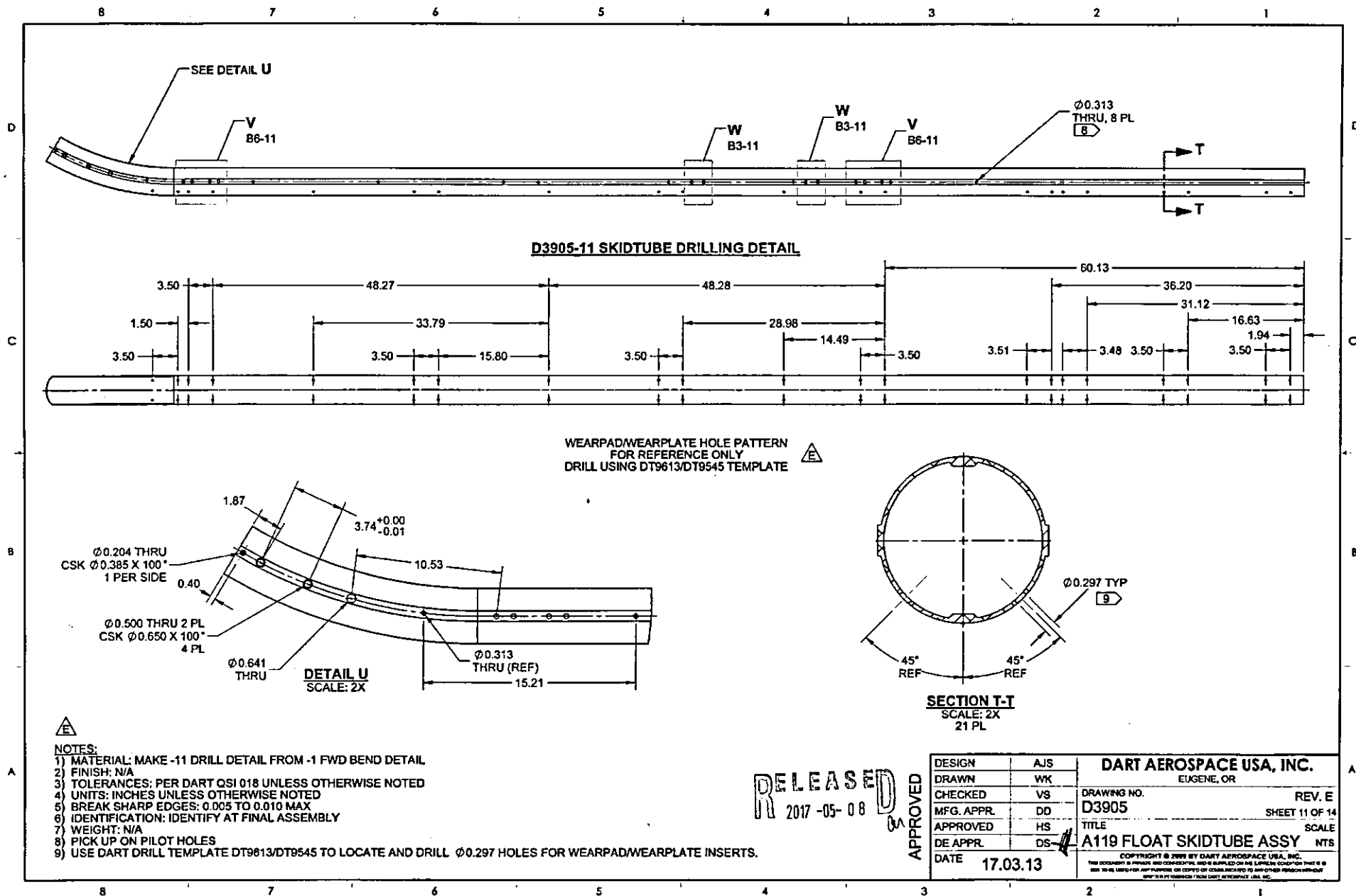
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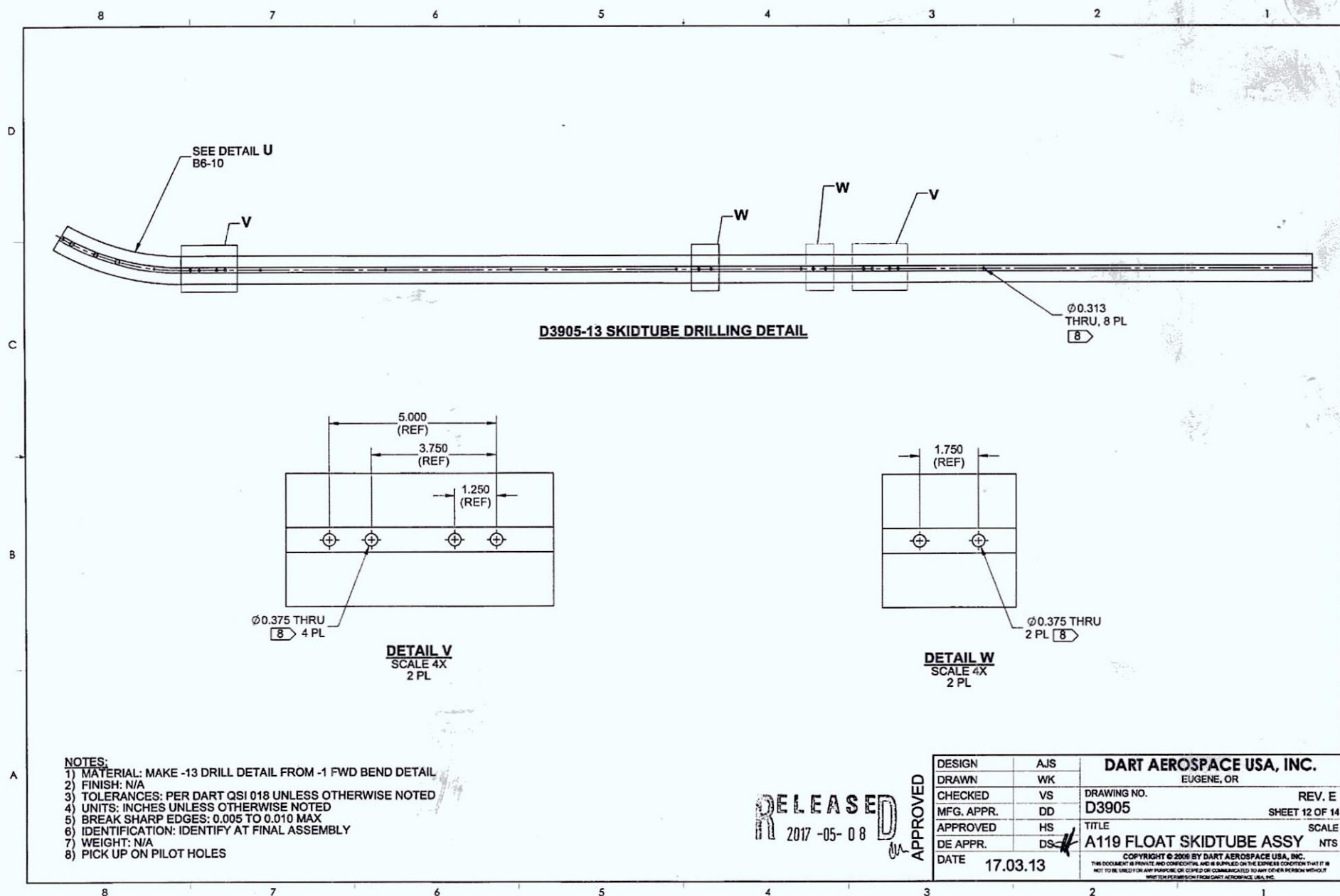
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

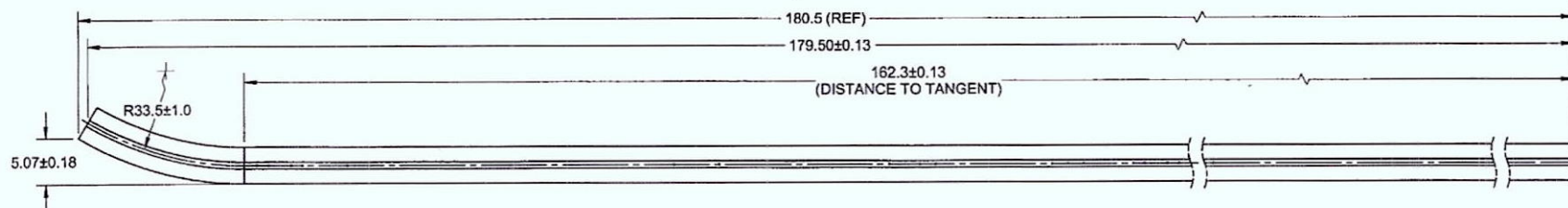
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D3905-1 SKIDTUBE FWD BEND DETAIL

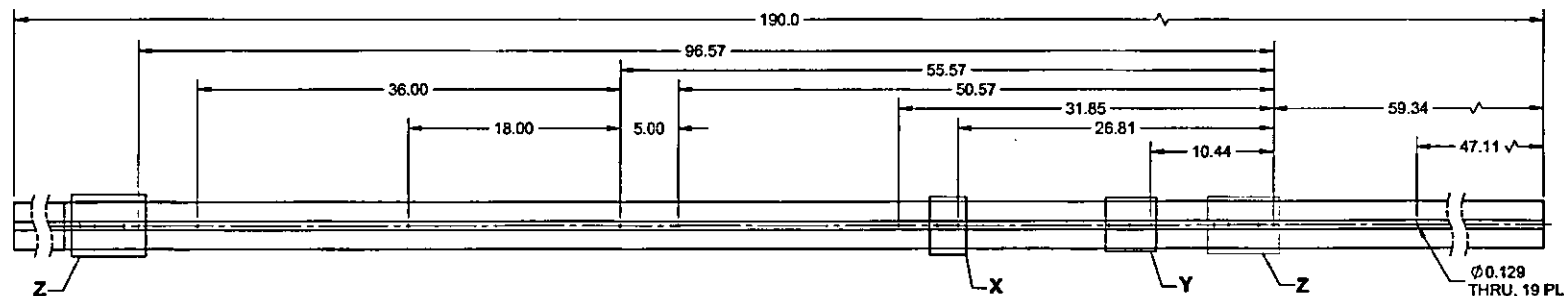
NOTES:

- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

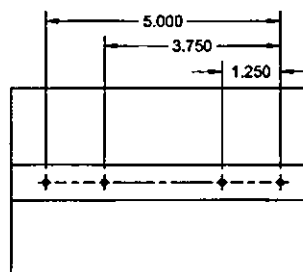
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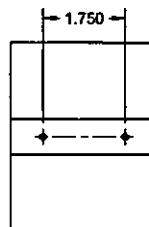
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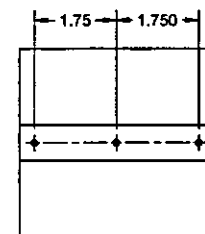
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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